



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D350-600-541
Job Sheet 192311



Part No: D350-600-541

Job Qty: 1 pcs

Part Name: Sliding Door Hinge, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/21/19

Job Tracking No:

Due Date: 4/17/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *orneln 14697*

Note: IIN-D350-600 REV E, DSI9814 REV A IPP RevA: New issue DD verified by:EC IPP REV B: PER DSI 9814
REV.A 18/12/14 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs	4/17/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

DAS
28
9-89



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Container No: S172167



Part: D350-600-541

Job No: 192311

Serial No/Batch: S172167

Revision: E / A

Inspector:

Exp Date:

Instructions: TC STC SH93-88 Issue 6, FAA-STD SR000981

Plex 3/21/19 8:57 AM Dart.lajeunesse.marie

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 QC 4	1 pcs	4/17/19	0.00 0.00		QC 4 - 28	
					QC 4 - 58	DAS
					QC 4 - 69	69
					QC 4 - 9	9-89
					QC 4 - 46	DAS
130 Packaging 3-1 - Stock - B4B	1 pcs	4/17/19	0.00 0.00		Packaging 3 - 1 - B4B	69
					Packaging 3 - 2 - B4B	9-89
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
140 DC - 1 - B4B	1 pcs	4/17/19	0.00 0.00		DC - 1 - B4B	21
					DC - 2 - B4B	9-89
150 QC 21 - FG	1 pcs	4/17/19	0.00 0.00		QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-89

Part Op 130 - Identify and pack for shipping as per PPP D350-600-541 Location: _____
 Descriptions: 140 - (Document Control) Photocopy blue file and create labels as per PPP D350-600-541 chg 002

009239

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-5A	Bolt	3 Ea (3 ea)	110-Packaging 1 - Pick Kit	5149158
AN3-6A	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5149149
AN310-4	Nut	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5167225
AN4-17	Bolt	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	F113121
AN970-4	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5114901
CR3243-4-3	Cherry Rivet	15 Ea (15 ea)	110-Packaging 1 - Pick Kit	F113749-40
CR3243-4-4	Cherry Rivet	10 Ea (10 ea)	110-Packaging 1 - Pick Kit	109252
D3552-11	Door Prop	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5161541
D3622-3	Ball Stud	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	F114882
D3816-1	Spacer	2 pcs (2 ea)	110-Packaging 1 - Pick Kit	5149151
D3816-3	Spacer	4 pcs (4 ea)	110-Packaging 1 - Pick Kit	5144144
D3956-1	Hinge, Airframe Upper	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	52922
D3956-3	Hinge, Airframe Lower	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	52923
D3957-041	Hinge Assembly, Door LH Upper	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	65025
D3957-043	Hinge Assembly, Door LH Lower	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5140918
D3968-1	Backing Plate, Door Hinge	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	52931
D3968-3	Backing Plate, Airframe Hinge	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	52933
D3991-1	Packer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	52934
D3991-3	Packer	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5087363
D3992-1	Reinforcement	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5169411
D3992-3	Reinforcement	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	5169409
MS21042L3	Nut	11 Ea (11 ea)	110-Packaging 1 - Pick Kit	5157462
MS24665-212	Cotter Pin	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	F125044
MS24693-S275	Screw	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5088023
MS24693S274	Screw	2 (2 ea)	110-Packaging 1 - Pick Kit	F124670
NAS1149C0363R	Washer	2 Ea (2 ea)	110-Packaging 1 - Pick Kit	5132615
NAS1149D0363J	Washer	9 Ea (9 ea)	110-Packaging 1 - Pick Kit	5152662

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3-5A	3	359	0
	AN3-6A	2	449	0
	AN310-4	2	105	0
	AN4-17	2	35	0
	AN970-4	2	64	0
	CR3243-4-3	15	138	0
	CR3243-4-4	10	145	0
	D3552-11	1	23	0
	D3622-3	2	8	0
	D3816-1	2	0	0
	D3816-3	4	16	0
	D3956-1	1	4	0
	D3956-3	1	8	0
	D3957-041	1	1	0
	D3957-043	1	11	0
	D3968-1	1	1	0
	D3968-3	1	5	0
	D3991-1	1	14	0
	D3991-3	1	14	0
	D3992-1	1	2	0
	D3992-3	1	0	0
	MS21042L3	11	3,325	0
	MS24665-212	2	123	0
	MS24693-S275	2	88	0
	MS24693S274	2	0	0
	NAS1149C0363R	2	567	0
	NAS1149D0363J	9	1,803	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

4.0 PARTS LIST

The Parts List for the DSI 9814-011/-012 Replacement Hinge Kits is as follows:

QTY -011	QTY -012	Part Number	Description
X		DSI 9814-011	Replacement Hinge Kit, LH
	X	DSI 9814-012	Replacement Hinge Kit, RH
1		D3957-043	Lower Door Hinge Assembly (Rev. B or later)
	1	D3957-044	Lower Door Hinge Assembly (Rev. B or later)
2	2	MS21042L3	Nut
1	1	MS24665-212	Cotter Pin
2	2	MS24693S275	Screw
2	2	NAS1149C0363R	Washer

The Parts List for the D350-600-541/-542 Sliding Door Hinge Kits is revised as follows:

WAS:

QTY -541	QTY -542	Part Number	Description
X		D350-600-541	LH Sliding Door Hinge Kit (at CHG 001)
	X	D350-600-542	RH Sliding Door Hinge Kit (at CHG 001)
1		D3957-043	Lower Door Hinge Assembly (Rev. A)
	1	D3957-044	Lower Door Hinge Assembly (Rev. A)
4	4	MS24693S274	Screw
11	11	NAS1149D0363J	Washer

IS:

QTY -541	QTY -542	Part Number	Description
X		D350-600-541	LH Sliding Door Hinge Kit (at CHG 002 or later)
	X	D350-600-542	RH Sliding Door Hinge Kit (at CHG 002 or later)
1		D3957-043	Lower Door Hinge Assembly (Rev. B or later)
	1	D3957-044	Lower Door Hinge Assembly (Rev. B or later)
2	2	MS24693S274	Screw
2	2	MS24693S275	Screw
2	2	NAS1149C0363R	Washer
9	9	NAS1149D0363J	Washer

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN	VS		
CHECKED	RF	DRAWING NO.	SHEET 5 OF 5
MFG. APPR.	N/A	DSI 9814	
APPROVED	DSW	TITLE	SCALE
DE APPR.	DS	REPLACEMENT LOWER HINGE NTS	
DATE	18.11.30	COPYRIGHT © 2018 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

REFERENCE ONLY

-541	-542	Part Number	Description
X		D350-600-541	LH SLIDING DOOR HINGE KIT
	X	D350-600-542	RH SLIDING DOOR HINGE KIT
1	1	D3956-1	HINGE, AIRFRAME UPPER
1	1	D3956-3	HINGE, AIRFRAME LOWER
1		D3957-041	HINGE ASSEMBLY, LH DOOR UPPER
	1	D3957-042	HINGE ASSEMBLY, RH DOOR UPPER
1		D3957-043	HINGE ASSEMBLY, LH DOOR LOWER
	1	D3957-044	HINGE ASSEMBLY, RH DOOR LOWER
2*	2*	D3815-3	ROD END
2	2	D3816-1	SPACER
4	4	D3816-3	SPACER
1	1	D3968-1	BACKING PLATE
1	1	D3968-3	BACKING PLATE
1	1	D3991-1	PACKER
1	1	D3991-3	PACKER
1		D3992-1	REINFORCEMENT
	1	D3992-2	REINFORCEMENT
1		D3992-3	REINFORCEMENT
	1	D3992-4	REINFORCEMENT
2	2	D3622-3	BALL STUD
1	1	D3552-11	GAS SPRING
3	3	AN3-5A	BOLT
2	2	AN3-6A	BOLT
2	2	AN4-17	BOLT
2	2	AN310-4	CASTLE NUT
2	2	AN970-4	WASHER
15	15	CR3243-4-3	CHERRY MAX RIVET
10	10	CR3243-4-4	CHERRY MAX RIVET
11	11	NAS1149D0363J	WASHER
2*	2*	NAS509-6	NUT
11	11	MS21042L3	NUT
2	2	MS24665-212	COTTER PIN
4	4	MS24693S274	SCREW

* Pre-installed on D3957-041/-042/-043/-044 Hinge Assemblies